Work Order ID 70017

Wednesday, May 25, 2011 12:03:18 PM

Item ID: D3023-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Back Panel

Start Date: 5/25/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/05/25 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3023	Rev A								
100		0.00							
Waterjet	FLOW WATER JET					HB 11-5-30			
FLOW CNC Waterjet	**Memo**	0.00							
2024.037	1-Cut as per Dwg D3023 Dwg Rev: A Prog Rev: A ***graind direction along 28.100" *** 2-Deburr if necessary								1
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC						HB 11-5-30			
Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									
130		0.00							
Brake NC	NC BRAKE					1			
Brake NC	**Memo**	0.00							
	1-Bend as per Dwg D3023□2-form edge of back pan as per dwg D3023 using D3017-041 back frame								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70017

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish						1	ϕ		11/06/14
	Memo	0.00							
Hand Finishing									
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat						1X	ϕ		11/06/14
	Memo	0.00							
Powder Coating	START TIME: 8:30 ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 9:00								
M 115128									
170	QC3- Inspect Part Finish	0.00							
QC						1	BR	11-6-14.	
	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70017

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Item Name: Back Panel

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: G-A	0.00							
Packaging	Memo w/o 70006	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/06/14

11/6/14

MF 11-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, May 25, 2011 12:03:15 PM

Work Order ID: 70017

Parent Item: D3023-1

Parent Item Name: Back Panel

Start Date: 5/25/2011 **Required Date:** 6/10/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP C□02.01.23□Revised□ NG□
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	39.9000	2.8777	3.029158			
2024-T3 .032 sheet										HB11-5-30			

Location	Loc Qty	Loc Code	
MAT22	39.9		
111699	0.5		
113189	39.4		113189

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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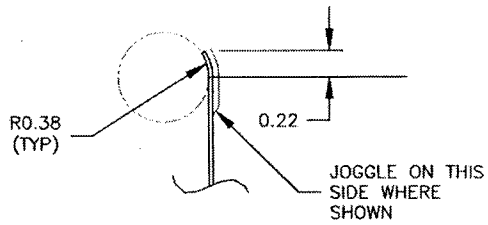
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

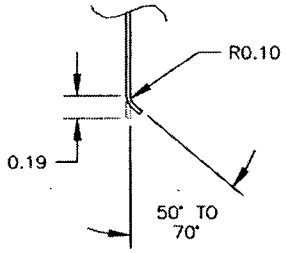
NOTE: Date & initial all entries

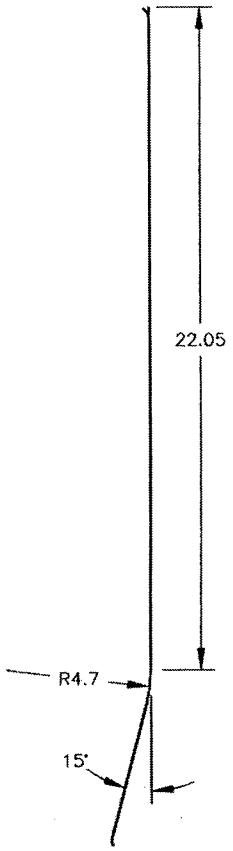
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SECTION A–A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

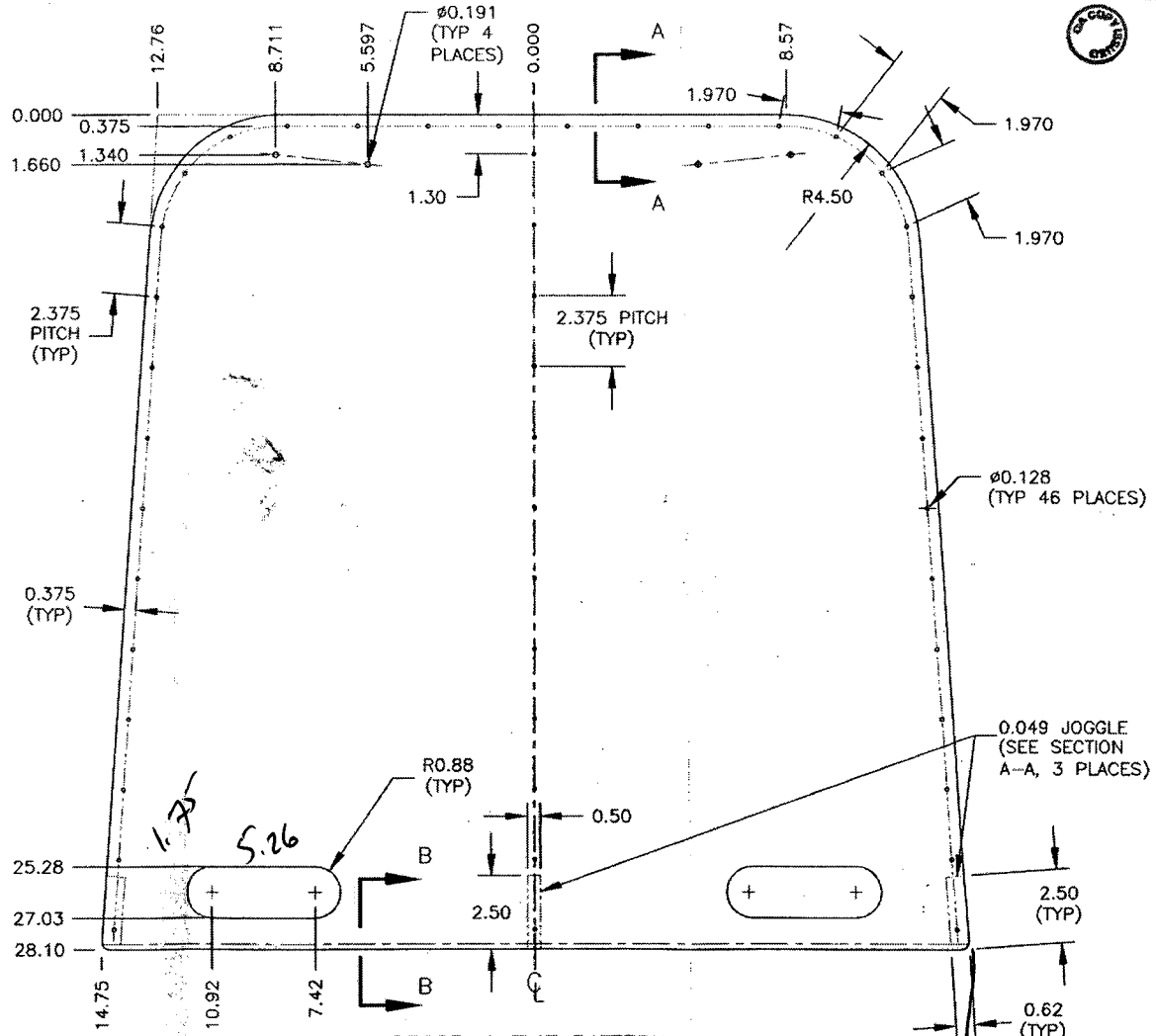


SECTION B–B
SCALE 1:1
(BOTTOM EDGE ONLY)





D3023–1 BEND DETAIL



D3023–1 FLAT PATTERN

RELEASED
01.06.07

CL 11/05/25
W/O: 70017

D3023–1 BACK PANEL:
1) MATERIAL: 2024–T3 (QQ–A–250/4) 0.032 THICK
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

A	01.05.18	NEW ISSUE	
DESIGN	DRAWN BY	DART AEROSPACE LTD. HARKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3023	REV. A
DATE 01.05.18		TITLE BACK PANEL	SHEET 1 OF 1 SCALE 1:4

DART AEROSPACE LTD	Work Order:	70017
Description: Back Panel	**Part Number:**	D3023-1
Inspection Dwg: D3023 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	X		V HB02	
Ø0.191	+0.005/-0.001	.191	X		V	
1.660	+/-0.010	1.658	X		V	
0.375	+/-0.010	.378	X		V	
1.340	+/-0.010	1.342	X		V	
2.375	+/-0.010	2.374	X		V	
0.375	+/-0.010	.376	X		V	
25.28	+/-0.030	25.28	X		T HB01	
27.03	+/-0.030	27.03	X		T	
28.10	+/-0.030	28.10	X		T	
1.30	+/-0.030	1.300	X		V	
2.375	+/-0.010	2.372	X		V	
8.711	+/-0.010	8.710	X		PRO W302	
5.597	+/-0.010	5.595	X		V	
8.57	+/-0.030	8.57	X		P	
1.970	+/-0.010	1.970	X		V	
7.42	+/-0.030	7.42	X		V	
10.92	+/-0.030	10.92	X		P	
14.75	+/-0.030	14.75	X		T	

Measured by:	[illegible]	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	11-5-36	Date:	11/05/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC [illegible]	[illegible]